

Work Order ID 162760

Monday, June 12, 2017 11:48:31 AM

162760

Page 1

Item ID: D3910-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Lug
Start Date: 6/12/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 7/3/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: JUN 12 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	E								
110	Outsource process - Machining	0.00							
110	HAAS CNC VERTICAL MACHINING #1								
Outsource5	Memo	0.00							
Outsource process - Machining	Issue P/O to ATG: <u>36680</u>								
	MANUFACTURE AS PER DWG								
	C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.40							
Packaging	Ensure C of C is attach								
130	QC6- All purchased or subcontracted products	0.00							
130									
QC	Memo	0.00							
Quality Control									

JUN 27 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																												
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																								
Root Cause		FAULT CATEGORY																																																														
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Misaligned/off center ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																															

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <i>57524</i>	0.00							
180						<i>20</i>		<i>JUL 05 2017</i>	<i>DAS 6</i>
Packaging	Memo	0.20							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	2.00							
Quality Control									

17/7/6

JUL 05 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
24 0 1				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, June 12, 2017 11:48:36 AM

Page 1

Work Order ID: 162760

162760

Parent Item: D3910-5

D3910-5

Parent Item Name: Crosstube Lug

Start Date: 6/12/2017

Required Date: 7/3/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS
13.09.26 AS PER REV.D DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 *D2423* Lug Extrusion		Manufactured	No			110	f	304.4802	0.12	2.526316			DAS 13 9-89
									**			JUN 13 2017	

Location

Loc Qty

Loc Code

Metec

304.4801737

115229

64

127892

83.2745647

148835

157.205609

D3910-5P

Purchased

No

110

Each

0.0000

1

20

D3910-5P

Crosstube Lug

**

20xSP17-6-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

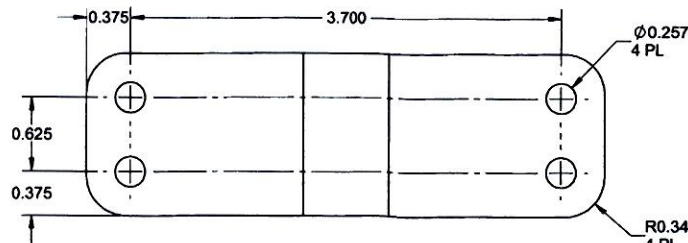
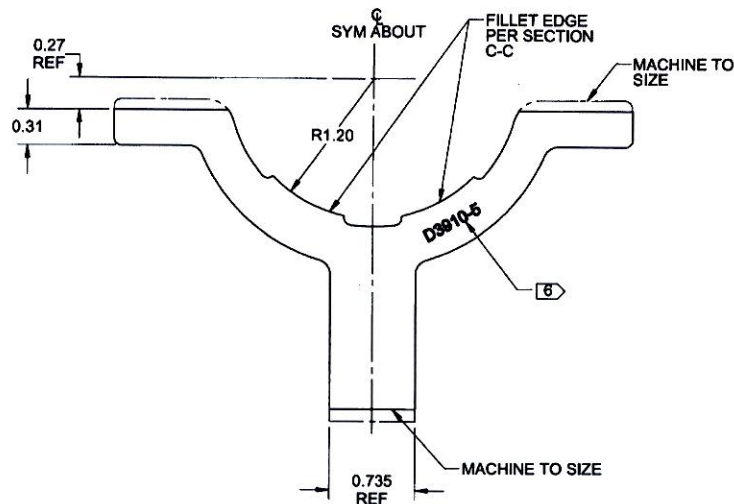
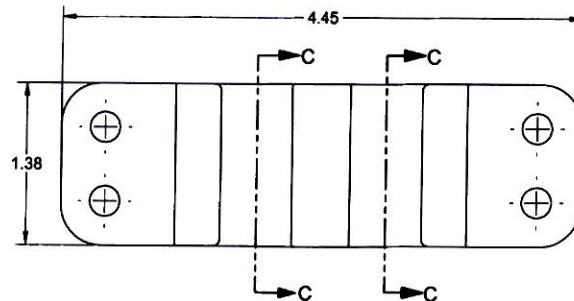
Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																

SECTION C-C

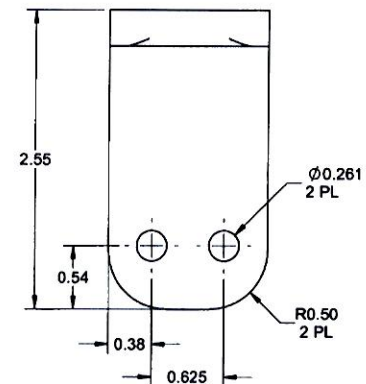


ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-5 X-TUBE LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *162750 M15*
1706-12



RELEASED

2014 JUN 05 *q*

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. E SHEET 4 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE X-TUBE LUG (350)	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	14.05.16		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36680**

Purchase Order Date 6/13/2017

PO Print Date 6/19/2017

Page Number 3 of 4

Order From :

METEC METAL TECHNOLOGY INC.
20 TERRY FOLK DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613 678 3957

Ship To Contact
Ship To Phone
Ship Via: Dart Truck
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

Line Total: \$563.50

6	D3910-3P	Crosstube Lug	6/20/2017	30.00	\$16.10	\$483.00
			Yes	Each		
			6/20/2017			

AS PER DWG D3910 REV. E
B162759
ALODINE AND PAINT AS PER QSI005

Line Total: \$483.00

7	D3910-5P	Crosstube Lug	6/20/2017	20.00	\$16.10	\$322.00
			Yes	Each		
			6/20/2017			

AS PER DWG D3910 REV. E
B162760
ALODINE AND PAINT AS PER QSI005

Line Total: \$322.00

Note:

6/19/2017

DAS
38
9-89



21 Terry Fox Drive
 Vankleek Hill, Ontario K0B 1R0 Canada
 Tel: (613) 678-3957
 Fax: (613) 678-3956

Delivery Slip No.: 21746
Date: Jun 20, 2017
Page: 1

Sold to:		Ship to:	
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury Ontario K6A 1K7		Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury Ontario K6A 1K7	
Order No.: 3630	Sold By: Walz, Christian D.		
Shipped By: your truck	Ship Date: Jun 20, 2017		

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
✓ D2230-3 Mounting Lug alodined and painted as per QSI005 not stock # 8 E/A Jun 12, 2017	Each	220	162 ✓	58
✓ D3235-1 Mounting Lug alodined and painted as per QSI005	Each	50 ✓	50 ✓	
✓ D3235-1 Mounting Lug alodined and painted as per QSI005	Each	100 ✓	100 ✓	
✓ D3294-2 Lug alodined and painted as per QSI005	Each	20 ✓	20 ✓	
✓ D3910-1 Crosstube Lug alodined and painted as per QSI005	Each	20	35 ✓	
✓ D3910-3 Crosstube Lug alodined and painted as per QSI005	Each	20	30 ✓	
✓ D3910-5 Crosstube Lug alodined and painted as per QSI005	Each	20 ✓	20 ✓	
DAS 38 8-89				
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by: <u><i>S. F. Leade</i></u>		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

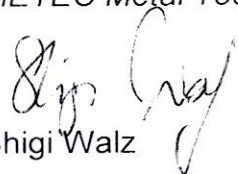
same

Quantity	Part Number	Part Name	Material Batch #	Paint Batch #	P.O. Number
162	D2230-3	Mounting Lug	148835	21012	36680
50	D3235-1	Mounting Lug	148835	21003	36680
100	D3235-1	Mounting Lug	148835	21003	36680
20	D3394-3	Lug	127892	20100	36680
35	D3910-1	Crosstube Lug	148835	21003	36680
30	D3910-3	Crosstube Lug	148835	21012	36680
20	D3910-5	Crosstube Lug	148835	20715	36680

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, June 20, 2017